

Monday, March 30, 2015 9:13:01 AM

131 194

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Clamp Cushion

Stop *NS2*

Start Date: 3/30/2015 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 3/30/2015 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals: Process Plan: MUS Date: 15-03-30 Tooling: Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5123	C

100

0.00

100

Mill Conv

Conventional Milling Machine

Memo

1-Mill as per DWG

0.00

DWG REV:

2-Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

40 0 J.C.-L
15/04/00

40 ~~0~~ J.C-L
15/04/00

Work Order ID 131194

Monday, March 30, 2015 9:13:01 AM

131194

Page 2

Item ID: D5123-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Clamp Cushion
Start Date: 3/30/2015 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 3/30/2015 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC8- Inspect parts - second check	0.00				40	0		
120	Memo	0.00							
QC									
Quality Control									

DAS
40
9-89

15/04/09

130	Identify as per dwg & Stock Location L655	0.00				40			
130	Memo	0.00							
Packaging									
Packaging									

DAS
6
9-89

APR 13 2015

140	QC21- Final Inspection - Work Order Release	0.00							
140	Memo	0.00							
QC									
Quality Control									

ML5 1504-13

MF 15-4-13

Picklist Print

Monday, March 30, 2015 9:13:03 AM

Page 1

Work Order ID: 131194

131194

Parent Item: D5123-7

D5123-7

Parent Item Name: Clamp Cushion

Start Date: 3/30/2015

Required Date: 3/30/2015

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A 15.03.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No				f	25.7700		14			
D4287-1									**				
Uhmw U-Channel													

J.C.L. 15/04/08

Location

Loc Qty

Loc Code

ST479a

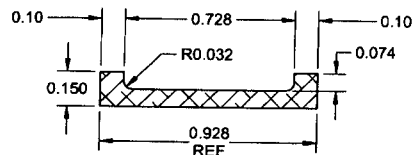
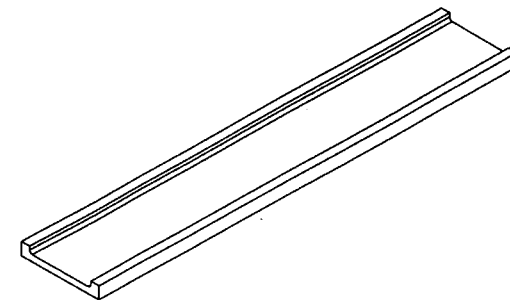
25.77

127169

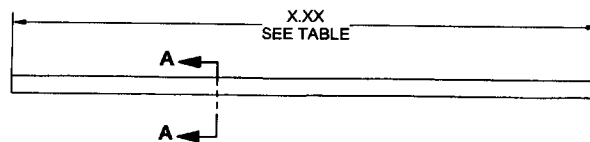
25.77

13.742

131194 MCLJ
15-03-30



SECTION A-A
SCALE 2X



D5123-Y CLAMP CUSHION

PART NUMBER	LENGTH X.XX (IN)
D5123-1	5.00
D5123-3	4.25
D5123-5	6.00
D5123-7	3.95



RELEASE

2015 MAR 18
ECN 15-547

- NOTES:**
 1) MATERIAL: MAKE FROM D4287-1
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.7
 7) WEIGHT: LESS THAN 0.01 lbs

C	ADD D5123-7	CP	15.01.21
B	ADDED D5123-5 CLAMP CUSHION, ADDED TABLE, ADDED THICKNESS TO PART	AP	14.08.19
A	NEW ISSUE	AP	14.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D5123	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP CUSHION	NTS
DATE	15.01.21	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED